










Work Order ID 63042

Monday, October 18, 2010 1:02:55 PM




Page 1


Item ID: D3580-1 Accept  Setup Start 
 Revision ID: 
 Item Name: Joggle Bracket Stop 
 Start Date: 10/18/2010 Start Qty: 60.00  Cust Item ID:
 Required Date: 10/26/2010 Req'd Qty: 60.00  Customer:
 Reference:


Approvals: Process Plan:  Date: 10/10/10 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

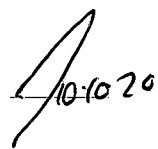
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3580	Rev B

100	FLOW WATER JET	0.00							
 Waterjet	Memo	0.00							
FLOW CNC Waterjet 364. G50	1-Cut as per Dwg D3580 Dwg Rev:  Prog Rev:  2-Deburr if necessary								(124)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
 QC	Memo	0.00							
Quality Control									

124 counted in 10's 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63042

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Page 2

Item ID: D3580-1

Accept

Revision ID:

Item Name: Joggle Bracket

Start Date: 10/18/2010 Start Qty: 60.00

Required Date: 10/26/2010 Req'd Qty: 60.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Bend as per dwg D3580 using 1/8" offset die

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location

0.00

Memo

0.00

SB 10/10/10
Debar 1st
@ 100

124

124

QSP019

10/10/10

124

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63042

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Page 3

Item ID: D3580-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Joggle Bracket

Start Date: 10/18/2010 Start Qty: 60.00

Required Date: 10/26/2010 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/21 *[Signature]*
ME
10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 1:03:00 PM

Page 1

Work Order ID: 63042



Parent Item: D3580-1



Parent Item Name: Joggle Bracket

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	94.8879	0.01	0.631579		13	



304/316 .050 Sheet



10-10-20

Location

Loc Qty

Loc Code

MAT20

94.8879

111743

6.55

112885

0.1679

113062

40.17

115389

48

112885

103

W/O:		WORK ORDER CHANGES					
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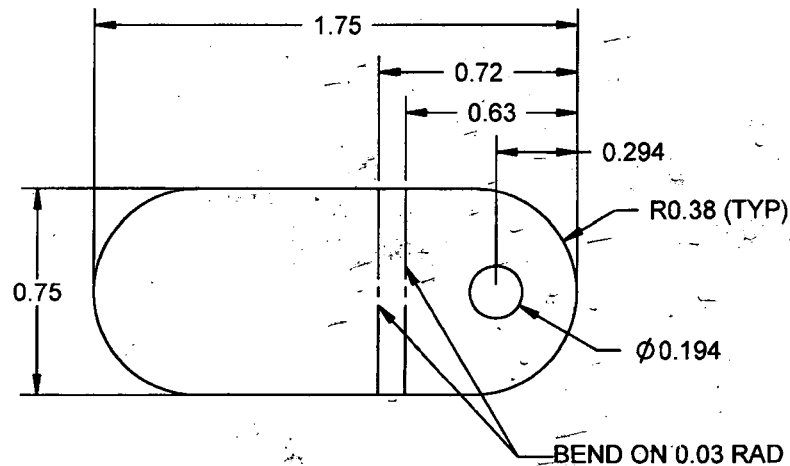
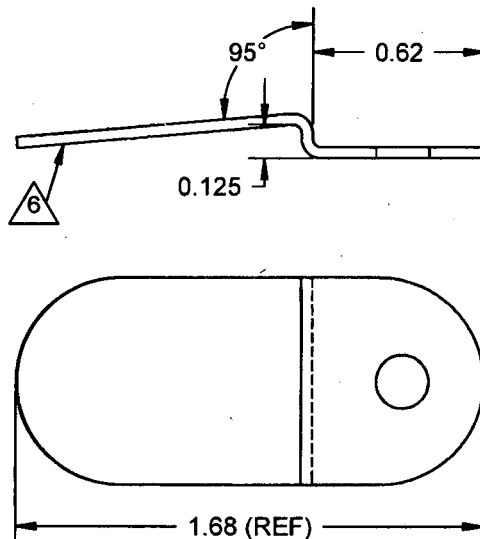
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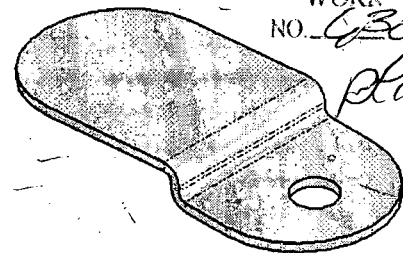
DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED07.07.09 *[Signature]***D3580-1F FLAT PATTERN**

SHOP COPY
REF. ENG.
ENGINEER
UNCONTROLLED
SUBMIT TO A
WITHOUT
WORK

NO. *63042*
Plw1012

**D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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Dart Aerospace Ltd

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